Work Order I October-31-11 12:3		308		*758	108 *						Page 1	
Item ID: D32 Revision ID:	238-11			Accept	*N900	040	100)* s	etup Star	* * N	S1*	
Item Name: Plate	e								Stop	*N	S2*	
Start Date: 31/1	10/2011	Start Qty: 12.00	*12*		Cust Item I	D:						
Required Date: 09/1 Reference:	11/2011	Req'd Qty: 12.00	*12*		Customer:							
Approvals: Pr	ocess Pla	n: M.L.J	Date: 11 10 13	Tooling:	Da	ate:	_	R	un Star	17	R1*	
QQ	C:		Date:	SPC (Y/N):	Da	ate:			Stop	` *N	R2*	
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	_
Draw Nbr	Revi	ision Nbr								-	· · · · · · · · · · · · · · · · · · ·	_
D3238	Rev	С										
100				0.00			-			_		
100 Waterjet		FLOW WATER JET Memo		0.00				B11-11	- 7			
FLOW CNC Waterjet			Dwg D3238 Dwg Rev:_ cessary		<u> </u>					58)	
110		QC2- Inspect parts off ma	achine FAI/FAIB	0.00								
*11 0 *		Memo		0.00				B11-11				
Quality Control		Menio										
120		QC8- Inspect parts - seco	and check	0.00	,			countre	>			
120				8.1.1	1.7.			×28				
QC		Memo		$_{0.00}$ $\sim \infty / \sim$	10+				/			

Quality Control

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DATE	STEP	PRO	DCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No) :	PAR #:	Fault Cated	dorv:	NCR: Yes	No DC	Α:	Date:	
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***		esolution:	Disposition	n:ER NON-CONFORMA	QA: N/C C	losed: R) Verifi			
NCR:	Re	Description of NC	Disposition WORK ORDI	ER NON-CONFORMA Corrective Action Section Action Description	QA: N/C C	losed: R) Verifi	ication	Date: _	Approval
NCR:	Re	Description of NC	Disposition WORK ORDI	ER NON-CONFORMA Corrective Action Section Action Description	QA: N/C C	losed: R) Verifi	ication	Date: _	Approval
NCR:	Re	Description of NC	Disposition WORK ORDI	ER NON-CONFORMA Corrective Action Section Action Description	QA: N/C C	losed: R) Verifi	ication	Date: _	Approval
NCR:	Re	Description of NC	Disposition WORK ORDI	ER NON-CONFORMA Corrective Action Section Action Description	QA: N/C C	losed: R) Verifi	ication	Date: _	Approval

Work Order ID 75808 *75808* Page 2 October-31-11 12:39:49 PM Item ID: D3238-11 Accept *N900040100* Setup Start **Revision ID:** Item Name: Plate **Start Date: Start Qty: 12.00** 31/10/2011 **Cust Item ID: Required Date:** 09/11/2011 Req'd Qty: 12.00 **Customer:** Reference: Run Approvals: Process Plan: Date: **Tooling:** Date: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. **Work Center ID** Qty Qty Number Stamp Description **Run Hours** Code 130 Chemical Conversion Coat per QSI005 4.1 0.00 28 BR 11-11-8. *130* HandFinish 0.00 Memo Hand Finishing 140 QC3- Inspect Part Finish 0.00 *140* 0.00 Memo Quality Control Identify as per dwg & Stock Location: 150 0.00 *150* Packaging 0.00 Memo

Packaging

Dart Ae	rospace	Lia						_	
W/O:			OW	RK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:							
	Re	esolution:	Disposition):	QA: N/C CI	osed:		Date: _	
NCR:		,	WORK ORDE	ER NON-CONFORMAN	ICE (NCF	R)			
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description	Sign 8	k Sec	cation tion C	Approval Chief Eng	Approval QC Inspector
		•	Chief Eng	Chief Eng	Date				
									
						,			

Work Order ID 75808 *75808* Page 3 October-31-11 12:39:49 PM Item ID: D3238-11 Accept *N900040100* Setup Start **Revision ID:** Item Name: Plate 31/10/2011 **Start Date: Start Qty: 12.00 Cust Item ID: Required Date:** 09/11/2011 Req'd Qty: 12.00 **Customer:** Reference: Run Start Process Plan: _____ Tooling: **Approvals:** Date: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Reject Tool # Plan Accept Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp 160 QC21- Final Inspection - Work Order Release 0.00 *160* QC 0.00 Memo Quality Control

W/O:			W(C	ORK ORDER CHANG	ES			,	
DATE	STEP		PROCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #: _	Fault Cate	gory:	_ NCR: Yes	No DQA	\ :	Date:	
	R	esolution:	Disposition	n:	_ QA: N/C CI	osed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NCF	₹)			
DATE	STEP	Description of NC		Corrective Action Section		Verific		Approval	Approval
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Description Chief Eng	on B Sign & Date	k Section		Approval Chief Eng	Approval QC Inspector
DATE	STEP	Description of NC Section A	Initial	Action Description	Sign 8	k Section			
DATE	STEP	Description of NC Section A	Initial	Action Description	Sign 8	k Section			
DATE	STEP	Description of NC Section A	Initial	Action Description	Sign 8	k Section			
DATE	STEP	Description of NC Section A	Initial	Action Description	Sign 8	k Section			
DATE	STEP	Description of NC Section A	Initial	Action Description	Sign 8	k Section			
DATE	STEP	Description of NC Section A	Initial	Action Description	Sign 8	k Section			
DATE	STEP	Description of NC Section A	Initial	Action Description	Sign 8	k Section			
DATE	STEP	Description of NC Section A	Initial	Action Description	Sign 8	k Section			

Picklist Print

October-31-11 12:39:53 PM

Work Order ID: 75808

75808

Parent Item: Parent Item Name: Plate

D3238-11

D3238-11

Start Date: 31/10/2011

Required Date: 09/11/2011

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A New Issue 06-10-20 EC

Now on Waterjet 07-01-26 JLM IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.020		Purchased	No			100	sf	0.0000	0.012	0.151579	>,		
*M5052H3	325 020	*							**	H211	-11-7		

5052-H32 .020 Sheet

6061,020

112442

m606165.020

W/O:				WOF	RK ORDER CH	ANGES					
DATE	STEP	PF	ROCEDURE	E CHANG	GE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			100000000000000000000000000000000000000								
								,			
Part No);	PAR #:	Faul	t Catego	ory:	NC	R: Yes	No DQ	4 :	Date: _	
	Re	esolution:	Disp	osition:		Q/	A: N/C CI	osed:		Date: _	
NCR:			WORK	ORDE	R NON-CONFO	RMANC	E (NCF	R)			
DATE	STEP	Description of NC			orrective Action	Section B	0:	Verific		Approval	Approval
DAIL	JILF	Section A	Initi Chief I		Action Descrip	otion 	Sign 8 Date	Section	on C	Chief Eng	QC Inspector
											
								1			

DART AEROSPACE LTD	Work Order:	75808
Description: Plate	Part Number:	D3238-11
Inspection Dwg: D3238 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

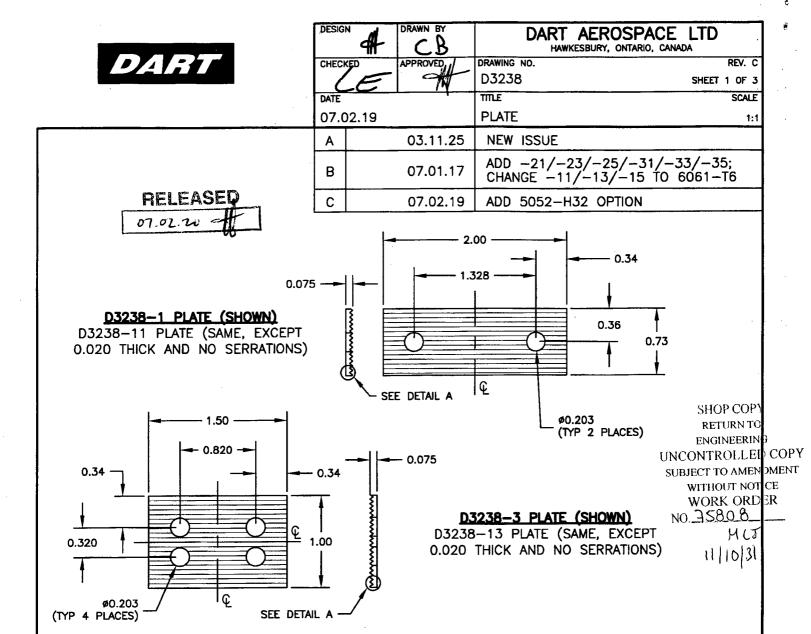
X	First Article	Prototype
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Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension	Toleranos	Dimension			Inspection	
2.00	+/-0.030	1,998	7		V B02	
0.72	+/-0.030	705	7		V	
0.36	+/-0.030	,363	8		ν	
0.34	+/-0.030	,336	8		V	
1.328	+/-0.010	1,330	>		V	
Ø0.203	+0.005/-0.001	-207	>		\ <u>/</u>	
		,			V	
		-				
		1				

Measured by: 🕏	Audited by:	Prototype Approval:	N/A
Date: 11-11-7	Date: WW 07	Date:	N/A

Rev	Date	Change	Revised by	Approved
AC	07.01.17	New Issue	KJ/JLM 1,A	
ВС	07.02.23	Dwg Rev. updated	KJ/JLM	E

W/O:	rospace		\M/O	DK ODDED CHANC					
	CTED			RK ORDER CHANG	T. 1			Approval	Approva
DATE	STEP	PRO	OCEDURE CHAI	NGE 	Ву	Date	Qty	Chief Eng / Prod Mgr	QC Inspecto
Part No	•	PAR #:	Fault Categ	jory:	_ NCR: Yes	No DQ	A:	_ Date: _	
	Re	esolution:	Disposition	:	_ QA: N/C C	losed:		Date: _	
NCR:			WORK ORDER NON-CONFORMA						
DATE	STEP	Description of NC			Section B Verificati			n Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector
				1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 -					
					1				



NOTES:

1) MATERIAL -1/-3/-5/-21/-23/-25 PLATE:

ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S)

-11/-13/-15/-31/-33/-35 PLATE:

ALUMINUM 6061-T6/-T62 SHEET, 0.020 THICK, PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.020) OR

ALUMINUM 5052-H32 SHEET, 0.020 THICK, PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.020)

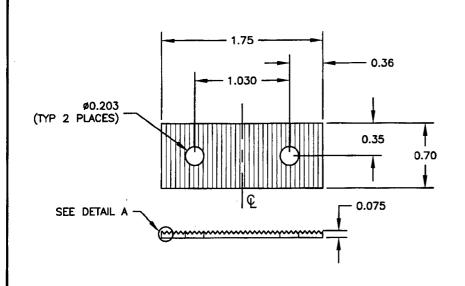
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) SEE SHEET 3 FOR DETAIL A
- 7) PARTS ARE SYMMETRIC ABOUT &

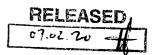
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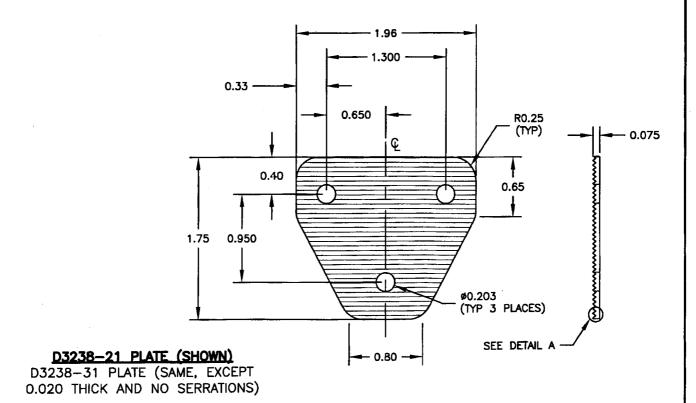
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DATE	STEP	PROCEDURE CHANGE				Ву	Date	Date Qty Approval Chief Eng / Prod Mgr				
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DATE	STEP	Description of NC	Corrective Action Section				Verific	Verification	Approval	Approval		
		Section A	Initial Chief Eng		escription Eng	Sign & Date	Secti		Chief Eng	al Approval QC Inspector		
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D3238-5 PLATE (SHOWN) D3238-15 PLATE (SAME, EXCEPT 0.020 THICK AND NO SERRATIONS)

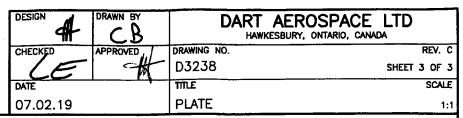


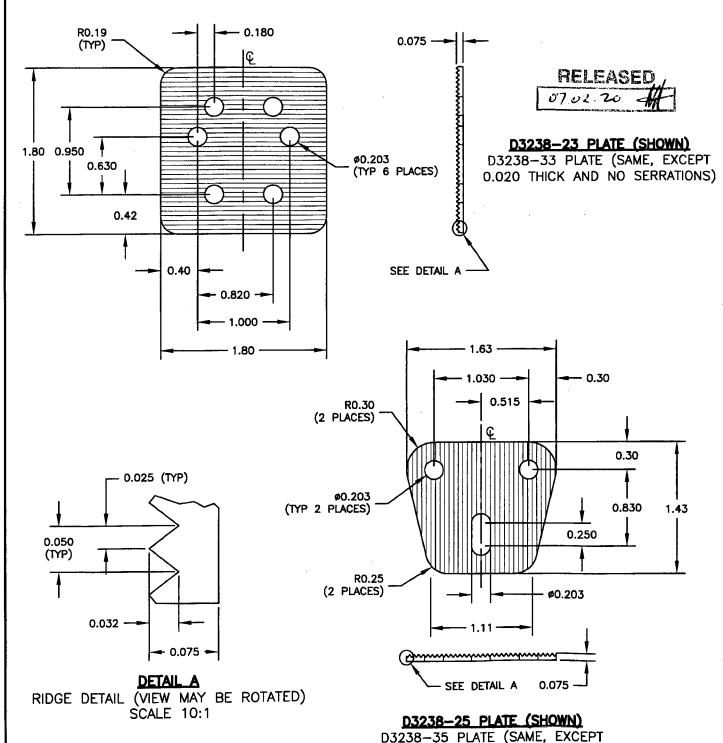
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W/O:			WC	RK ORDER CHANG	ES		<u> </u>				
DATE STEP		PRO	CEDURE CHAI	NGE	By Date Qty Approval Chief Eng / Prod Mgr QC II				Approval QC Inspector		
						,					
Part No:		PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	_ Date:			
Resolution:			Disposition: QA: N/C Clo				osed: Date:				
NCR:			WORK ORDI	R NON-CONFORM	ANCE (NCF	₹)					
DATE	CTED	Description of NC		tion B	Verifi	cation	Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign a	& Sec	tion C	Chief Eng	QC Inspector		
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0.020 THICK AND NO SERRATIONS)

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DATE	STEP	PRO	CEDURE CHAP	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto	
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